

GXP Primary and Secondary Blade Rotation

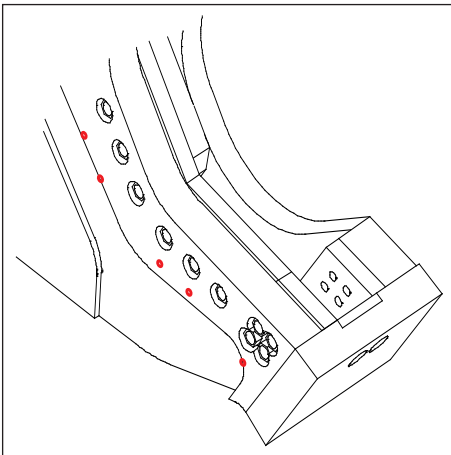
Proper maintenance of the primary and secondary blades, or cutting blades, is required for optimal performance. Blade rotation extends blade life and improves cutting performance. Shimming to maintain blade tolerances helps prevent jamming. Dull blades make the excavator hydraulic system work harder and may cause structural damage to the shear.

Inspect blades every eight hours of operation. Re-torque loose bolts and replace broken bolts. Grind away dents or mushrooming of blade edges at the end of each day to prevent upper jaw deflection, excessive blade wear and undue stress to upper and lower jaws.

Rotate blades to use all four cutting edges. Always use Genesis-approved blades. Blades that do not meet Genesis specifications can cause major problems, and using them may void the warranty.

REMOVAL

- ❑ Loosen the bolts on one blade at a time, enough to loosen the blades.
- ❑ If blades remain tight, insert a 7/16" brass drift pin into the through-hole on the lower jaw. Tap the drift pin with a hammer until the blade is loose.
- ❑ Carefully remove bolts and blades.

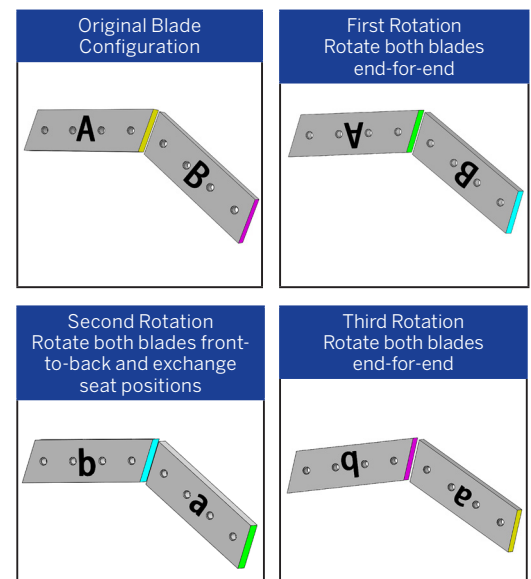


ADJUSTMENT PLATES

- ❑ Do not remove the adjustment plates from the lower jaw during routine blade rotation or replacement. These plates are custom-machined for each shear and need only be replaced when lost, damaged or extremely worn.
- ❑ Inspect the top of each adjustment plate and seat for burrs, nicks or other imperfections that may prevent proper seating of the blades and cause errant blade gap readings. Clean the adjustment plates as necessary.
- ❑ Replacement plates can be ordered from your Genesis dealer or the Genesis Parts Department with the serial number of your shear.
- ❑ Offset dowel or fastener holes are located in each adjustment plate. When replacing adjustment plates, make sure these holes are aligned with the corresponding holes in the blade seat.
- ❑ Do not grind blade seat areas.

ROTATION

- ❑ Rotate blades when the cutting edges are worn to a 1/8" (3 mm) radius.
- ❑ Recommended rotation intervals are approximately 40-80 hours, depending on the material being processed. Thin materials may require shorter rotation intervals. Blades must be replaced when all four edges are worn to 1/8" (3 mm) radius.



This document is a quick reference only. It does not replace the product safety and operator's manuals, which must be followed by all operators and maintenance personnel.

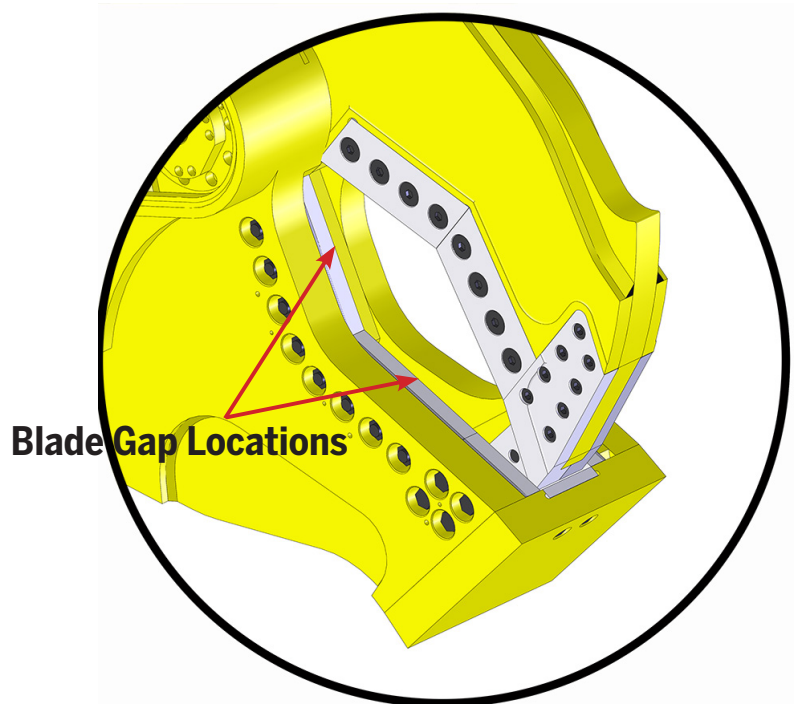
Blade Gap

After each blade rotation, shim the lower blades to keep the gap within the specifications listed in the table below. Do not shim the upper blades. Use only Genesis shim kits.

Cutting Blade Gaps		
Model	Minimum	Maximum
200 & 300	0.005"	0.015"
400	0.010"	0.020"
440 ¹	0.010"	0.020"
500	0.010"	0.020"
660	0.010"	0.020"
700	0.010"	0.020"
990 ¹	0.010"	0.020"
1000	0.010"	0.020"
990 ² , 1200 & 1500	0.015"	0.025"
2500	0.020"	0.030"

¹ 4 bolt tips

² 6 bolt tips



Blade Gap Measuring Procedure

Slowly close jaws until blades begin to bypass. Stop the jaw and check the gap with a feeler gauge.

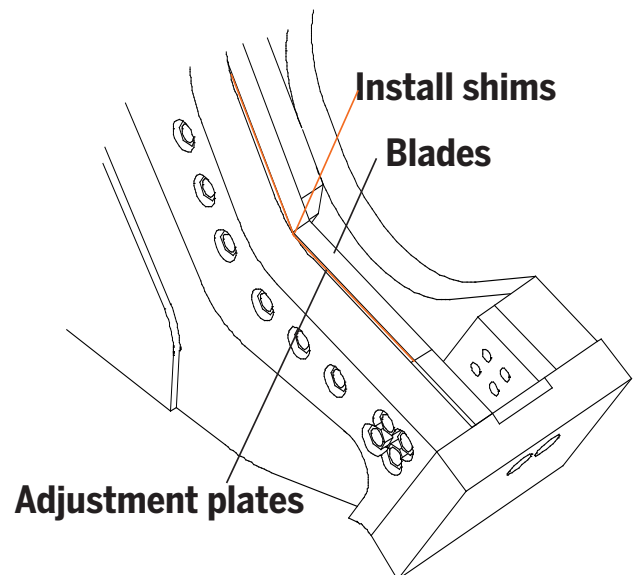
Cycle the jaws slowly and continue checking the gap at several points along the entire length of the blades.

Note: The gap will be consistent along the entire length of the blades if they have been rotated and shimmed correctly.

If the blade gap exceeds the maximum listed on the table above, shim the lower blades. Blades must be replaced when shims exceed 0.060".

Shimming

- ❑ Loosen blade bolts.
- ❑ Install shims between the blades and adjustment plates as needed to bring into tolerance.
- ❑ Torque bolts to spec and recheck the tolerances.
- ❑ Do not use more than 0.060" of shims.



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